

Date: Wednesday, 11/21/2007 12:47:44 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 35919	
Estimate Number : 10178	
P.O. Number : <i>N/A</i>	Part Number : D25941
This Issue : 11/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2594 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : C
Previous Run : 34997	Material : <i>N/A</i>
Type : MACHINED PARTS	Due Date : 1/15/2008
Written By : <i>[Signature]</i>	Qty: <i>200</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est D 02.08.22 Make in Cobra KJ	
est E 06.12.11 ecn 836 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0547 t(s)/Unit Total: 10.5034 t(s) *11.2833*

Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)

1100-0 (QQ-A-225/1) Ø0.625" Rod

(M5052H32R0.625) or (M6061T6R0.625)

Batch *M106103*

HARDINGE CNC LATHE SMALL

2.0 HARDINGE



Comment: HARDINGE CNC LATHE SMALL

1-Make as per Dwg D2594-1 and Folio FA262.

2-Break all sharp edges 0.010 max.

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

5.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/12/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M102316



Comment: POWDER COATING

~~*~~ Powder Coat **SANDTEX GREEN** ~~*~~

(Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

07-12-11

205x

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



205x

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-h

07/12/11

8.0

PACKAGING 1

PACKAGING RESOURCE #1



205x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FR 2

m-h

07/12/11

9.0

QC21

FINAL INSPECTION/W/O RELEASE



205

Comment: FINAL INSPECTION/W/O RELEASE

07/12/11

Job Completion



07/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35919
Description: Plug		Part Number:	D2594-1
Inspection Dwg: D2594 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.060				
0.500	+/-0.010	.4995				
0.625	+/-0.010	.622				
0.430	+0.000/-0.002	.429				
0.090	+0.000/-0.002	.0895				
0.045	+0.000/-0.002	.045				

Measured by: <i>KA/mk</i>	Audited by: <i>RC</i>	Prototype Approval:	N/A
Date: 07/11/26	Date: 07/11/27	Date:	

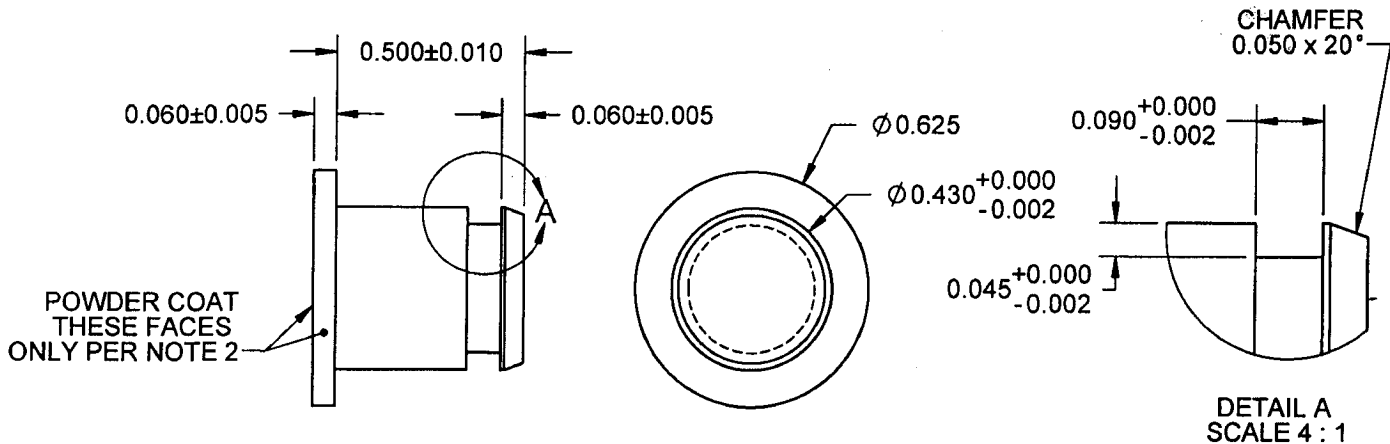
Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM <i>JA</i>	<i>JA</i>

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG		SCALE 2:1
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28

**D2594-1 PLUG NOTES:**

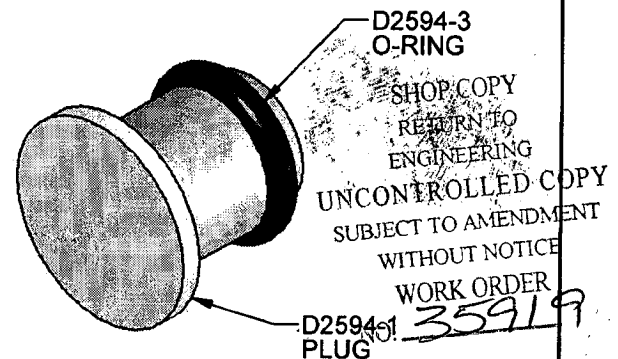
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 $\triangle C$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 $\triangle C$

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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